

Date: Wednesday, 1/23/2008 11:37:19 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 36924	
Estimate Number : 10347	
P.O. Number :	Part Number : D28572
This Issue : 1/23/2008 S.O. No. :	Drawing Number : D2857 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 33943	Material :
Written By :	Due Date : 2/20/2008 Qty: 24 Um: Each
Checked & Approved By : <u>JK 080123</u>	
Comment : Est C 00.06.22 Removed P/O for powder coat EC	
Est D 06.03.30 Added level 8 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
-----	--------------------	--------------------------



Comment: Qty.: 0.4594 f(s)/Unit Total : 11.0250 f(s)

Material: 2.00" X 1.25"

6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)

(M6061T6B200001250)

Batch 17105838

JK 08/02/12

(26)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks 5.2"

JK 08/02/12

(26)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2857-2

JK 08/02/19

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JK

08/02/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 08/02/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:37:19 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 36924

Part Number: D28572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8.5 08/02/19

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

J.L 08/02/19

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

JP 08-02-19 126

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.H 08/02/19 26x

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

JP 08-02-20 26x

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M.H 08/02/20 26x

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 50

8/2/21 26x

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/20 26

Job Completion



mi 2008/2/21 26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	36924
<b>Description:</b> Hinge Bracket		<b>Part Number:</b>	D2857-2
<b>Inspection Dwg:</b> D2857 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

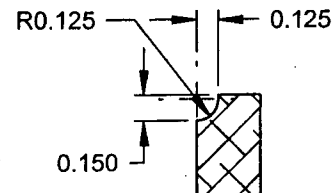
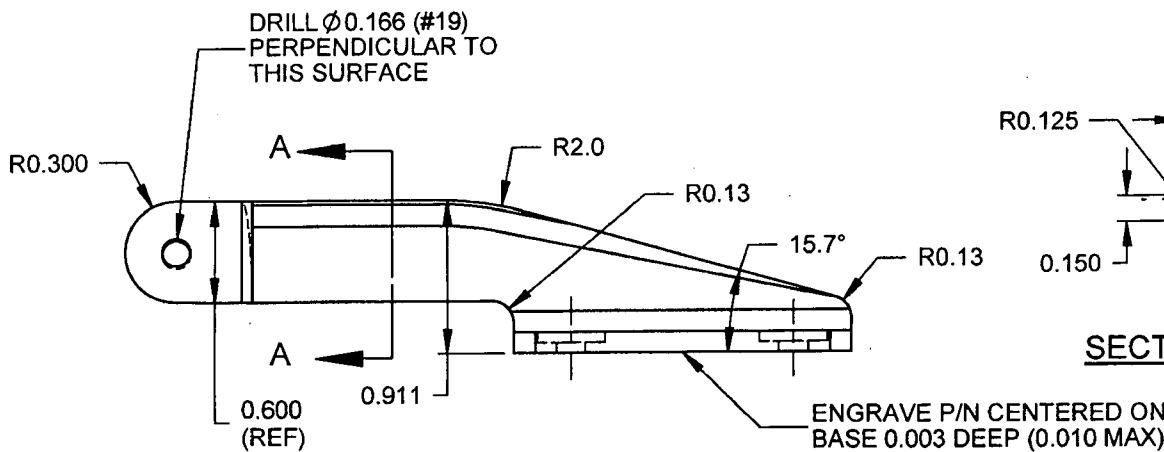
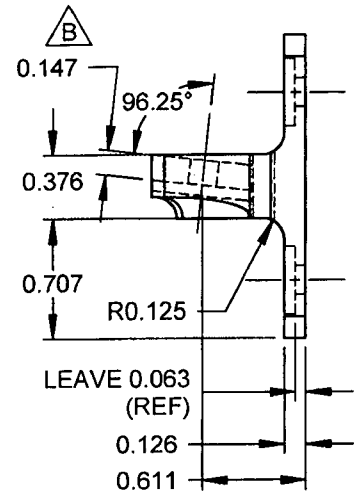
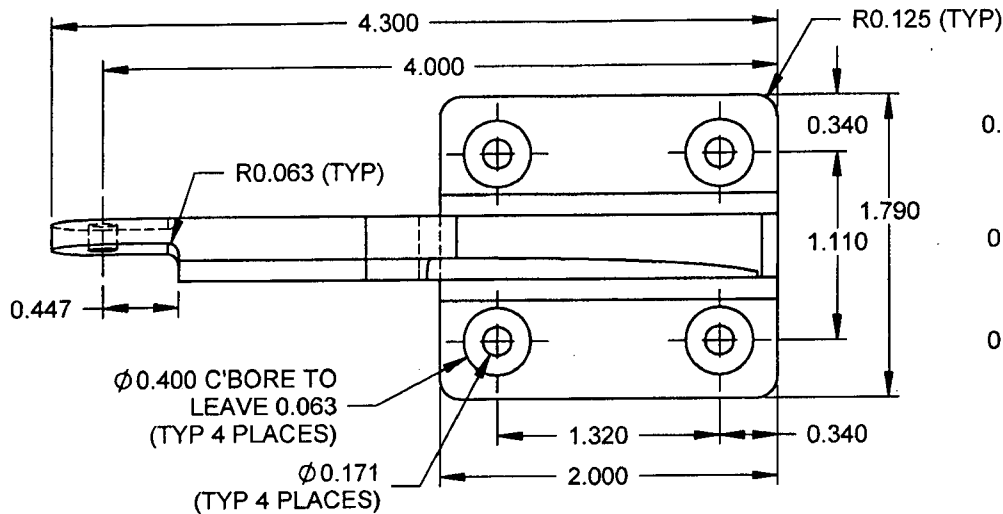
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.308	✓			
4.000	+/-0.010	4.001	✓			
0.340	+/-0.010	.340	✓			
1.110	+/-0.005	1.110	✓			
1.790	+/-0.010	1.790	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.001	✓			
0.340	+/-0.010	.340	✓			
0.447	+/-0.010	.447	✓			
Ø0.171	+0.005/-0.000	.172	✓			
0.147	+/-0.010	.148	✓			
0.376	+/-0.010	.379	✓			
0.126	+/-0.010	.126	✓			
0.063	+/-0.010	.065	✓			
Ø0.166	+0.005/-0.000	.167	✓			
0.911	+/-0.010	.917	✓			
0.600	+/-0.010	.610	✓			
0.125	+/-0.010	.125	✓			
0.150	+/-0.010	.150	✓			

<b>Measured by:</b>	SC	<b>Audited by:</b>	ml	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	08.02.18	<b>Date:</b>	08/02/18	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

**DART**

DESIGN KE	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2857</b>	REV. B SHEET 1 OF 1
DATE <b>06.08.28</b>	TITLE <b>HINGE BRACKET</b>		SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

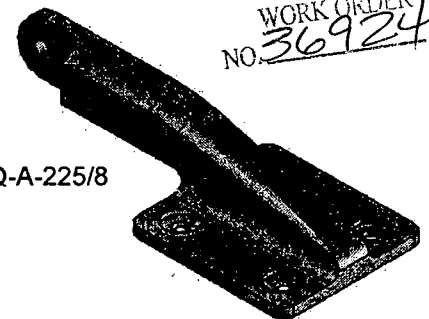
**RELEASED**  
06-10-13

SHOP COPY  
SECTION A-A  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36924

**D2857-1 HINGE BRACKET**  
**D2857-2 OPPOSITE**

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



**COPYRIGHT © 1998 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.